

Work Order ID 126691

Tuesday, December 09, 2014 3:06:07 PM

126691

Weldn. 7th
~~DEC 17~~
 Page 1

Item ID: D350-567-145 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Window Close Out (AS350 B3e)
 Start Date: 11/24/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/28/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
DSI 9590	E	<i>*SP</i>

MLS 14-12-16

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								

DAS 06 9-89 **DEC 17 2014**

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

IX SP14-12-16

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DEC 17 2014

DAS 06 9-89

Work Order ID 126691

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126691

Page 2

Item ID: D350-567-145 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Window Close Out (AS350 B3e)
 Start Date: 11/24/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/28/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-145								
	Location: <u>022</u> <u>SFP</u>								

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
 DAS 06 3-09
 DEC 17 2014
 MJS 14-12-17
 MF 14-12-17

Picklist Print

Tuesday, December 09, 2014 3:06:12 PM

Page 1

Work Order ID: 126691

126691

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/24/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CB200		Purchased		No			Each	19.0000					
-------	--	-----------	--	----	--	--	------	---------	--	--	--	--	--

CB200

Acrylic Adhesive, 3.5G

**

-1

129452

DAS
26
9-89

Location

Loc Qty

Loc Code

MF
m130685

19
19

Each 5.0000

**

1
B11/218

DAS
46
9-89

DAS
26
9-89

D4730-020-030

D4730-020-030

Velcro Strip 2.0W/ X 3.0L

Manufactured No

DAS
06
9-89

Location

Loc Qty

Loc Code

ST410
120056

5
5

Each 3.0000

**

1

DAS
46
9-89

DAS
26
9-89

D4971-041

D4971-041

T/R Bellcrank Cover Assembly

Manufactured No

DAS
06
9-89

Location

Loc Qty

Loc Code

ST621
120665
121193

3
2
1

Each 0.0000

**

1
126824

DEC 16 2014
DAS
46
9-89

DAS
26
9-89

D5076-041

D5076-041

Fwd Bracket Assembly

Manufactured No

DAS
06
9-89

Picklist Print

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Work Order ID: 126691

126691

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/24/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

D3802-1 Manufactured No

220.0100

D3802-1

Windows Seal (\$ Per Foot)

68-6
88
9-89

DEC 16 2014

**

DAS
46
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST421

220.01

112283

48

114190

9

116673

10

117766

0.01

122222

153

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9 Manufactured No

Each

4.0000

D4435-9

Bracket

DAS
86
9-89

Location

Loc Qty

Loc Code

ST107

4

125330

4

D4436-041 Manufactured No

Each

2.0000

D4436-041

Aft Bracket Assembly

DAS
86
9-89

Location

Loc Qty

Loc Code

ST622

2

126968

2

**

DAS
46
9-89
DEC 16 2014

DAS
28
9-89

Picklist Print

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Work Order ID: 126691

126691

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/24/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

D4441-1 Manufactured No

426.7478

D4441-1

Rubber Seal

DAS
38
9-89

DAS
86
9-89

**

DAS
46
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
ST407	425.7478	
120932	425.7478	
ST422	1	
86185	1	

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A Purchased No

Each 380.0000

AN3-3A

Bolt

**

DAS
46
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
ST338a	360	
m129591	360	
ST350	20	
m127815	3	
m129706	1	
m130466	16	

AN525-10R6 Purchased No

Each 210.0000

AN525-10R6

Screw

**

DAS
46
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
ST273A	100	
M129390	100	
ST329	110	
M127743	18	
M130005	7	
M130325	85	

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Shop Packet Print

Page 3

Picklist Print

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Work Order ID: 126691

126691

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/24/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

AN525-832R7

Purchased

No

Each

102.0000

27

AN525-832R7

**

DAS
46
9-89

DAS
26
9-89

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

80

m129909

80

ST329

22

120560

9

m127363

13

2x

MS21042L06

Purchased

No

Each

358.0000

7

MS21042L06

**

DAS
46
9-89

DAS
26
9-89

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST305

358

m127304

1

m129499

157

m130325

200

7x

MS21042L08

Purchased

No

Each

1,832.000

2

MS21042L08

**

DEC 16 2014

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST304

1832

123900

1

125445

202

m127304

99

m127410

44

m128401

715

m128429

69

m129541

102

m130325

600

2x

DAS
46
9-89

DAS
26
9-89

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Work Order ID: 126691

126691

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/24/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

Each 1,125.000

MS21042L3

Nut

**

DAS
46
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
FP001	486	
M130922	486	
ST305	639	
123900	13	
M127410	11	
M127831	41	
M128401	34	
M130799	540	

DAS
96
9-89

MS21059L3

Purchased No

Each 257.0000

MS21059L3

Nut Plate

**

DAS
46
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
CA	9	
M129682	9	
ST303	248	
M130823	248	

DAS
96
9-89

MS35206-229

Purchased No

Each 2.0000

MS35206-229

Screw

**

DEC 16 2014

Location	Loc Qty	Loc Code
ST277	2	
M129795	2	

DAS
96
9-89

DAS
46
9-89

DAS
26
9-89

Picklist Print

Tuesday, December 09, 2014 3:06:13 PM

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Work Order ID: 126691

126691

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/24/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

3,612.000

10

NAS1149F0332P

Washer

DAS
46
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

3000

m130325

2000

m131026

1000

st268

612

122063

205

123900

10

125646

106

m127831

291

DAS
86
9-89

NAS1149FN616P

Purchased

No

Each

212.0000

14

NAS1149FN616P

WASHER

DAS
46
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st268

212

M127703

12

M131026

200

DAS
86
9-89

NAS1149FN816P

Purchased

No

Each

546.0000

2

NAS1149FN816P

WASHER

14-12-16

Location

Loc Qty

Loc Code

st268

546

117316

546

DAS
86
9-89

DAS
46
9-89

DAS
28
9-89

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

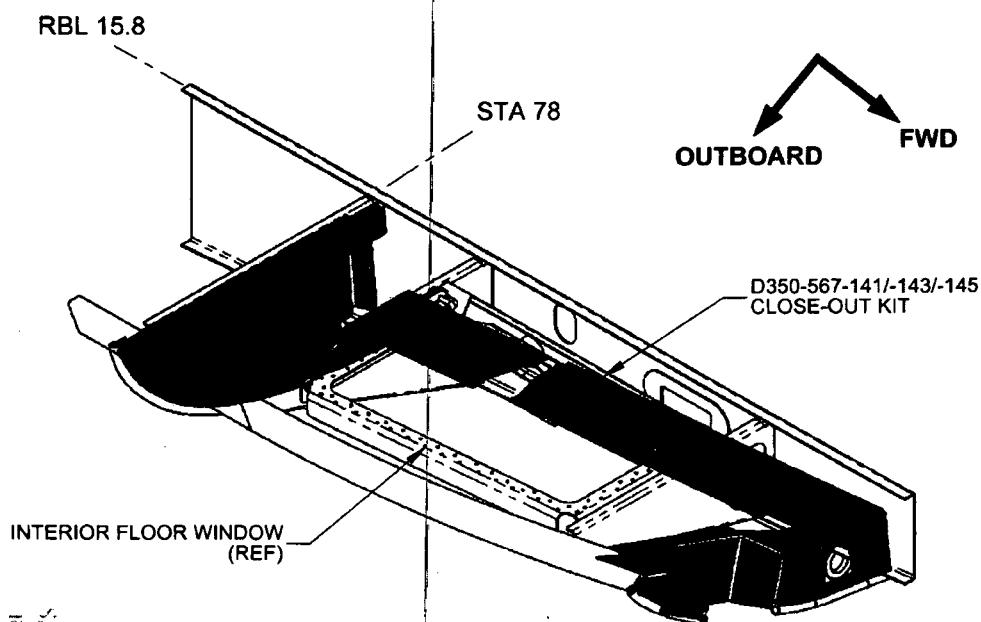


Figure 1. Floor Window Close-out Kit Installation

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITH NO VOICE
 WORK CENTER
 NO. 126691 M05
 14-12-05

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

E	ADD -143/-145 KITS	RF	14.03.20
D	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-832R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7; NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	14.03.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

E

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-k	1.66 m	2.94 m-k

4.0 Installation Procedure

Notes:



- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	14.03.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

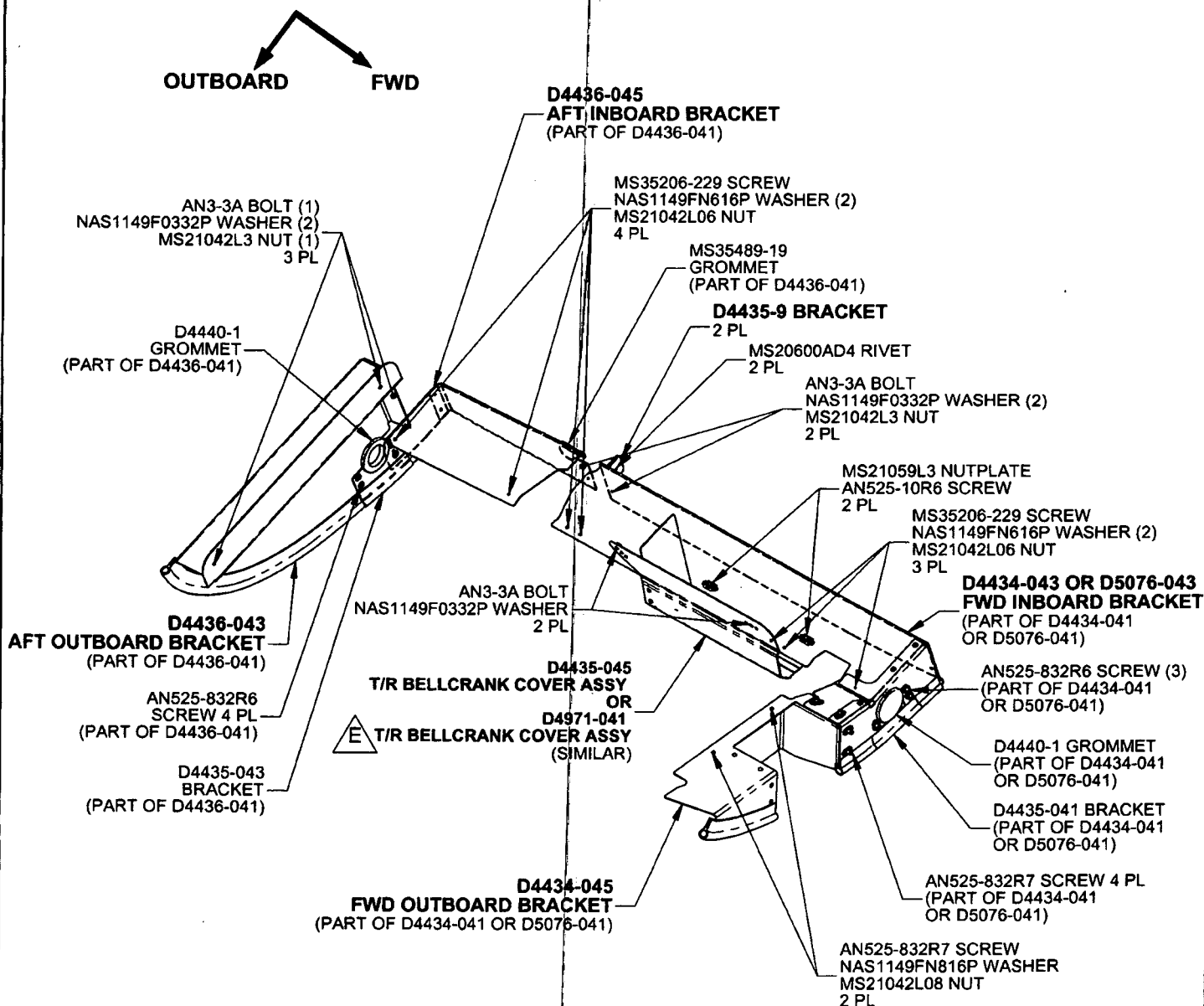




Figure 2. Floor Window Close-out Kit Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 3 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	14.03.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

4.3 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

E 4.4 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.6 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.7 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.8 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.9 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

E 4.10 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

E 4.11 FOR D350-567-143/-145 KIT

a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.

b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.

c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.

CANADA
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AIRCRAFT CERTIFICATION
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DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 4 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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


- d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
- e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.12 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.13 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.14 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.15 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

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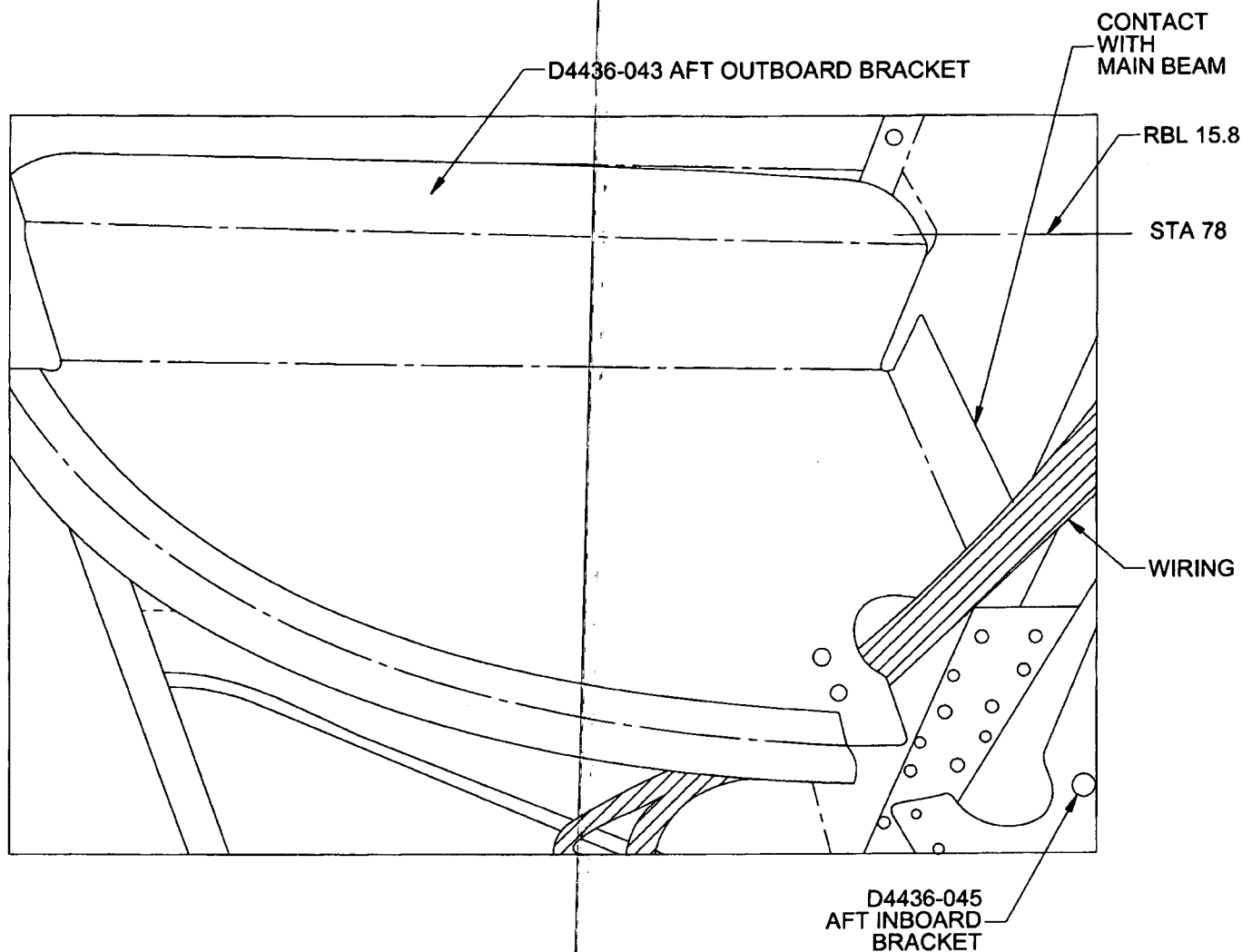


Figure 3. D4436-043 Aft Outboard Bracket Installation

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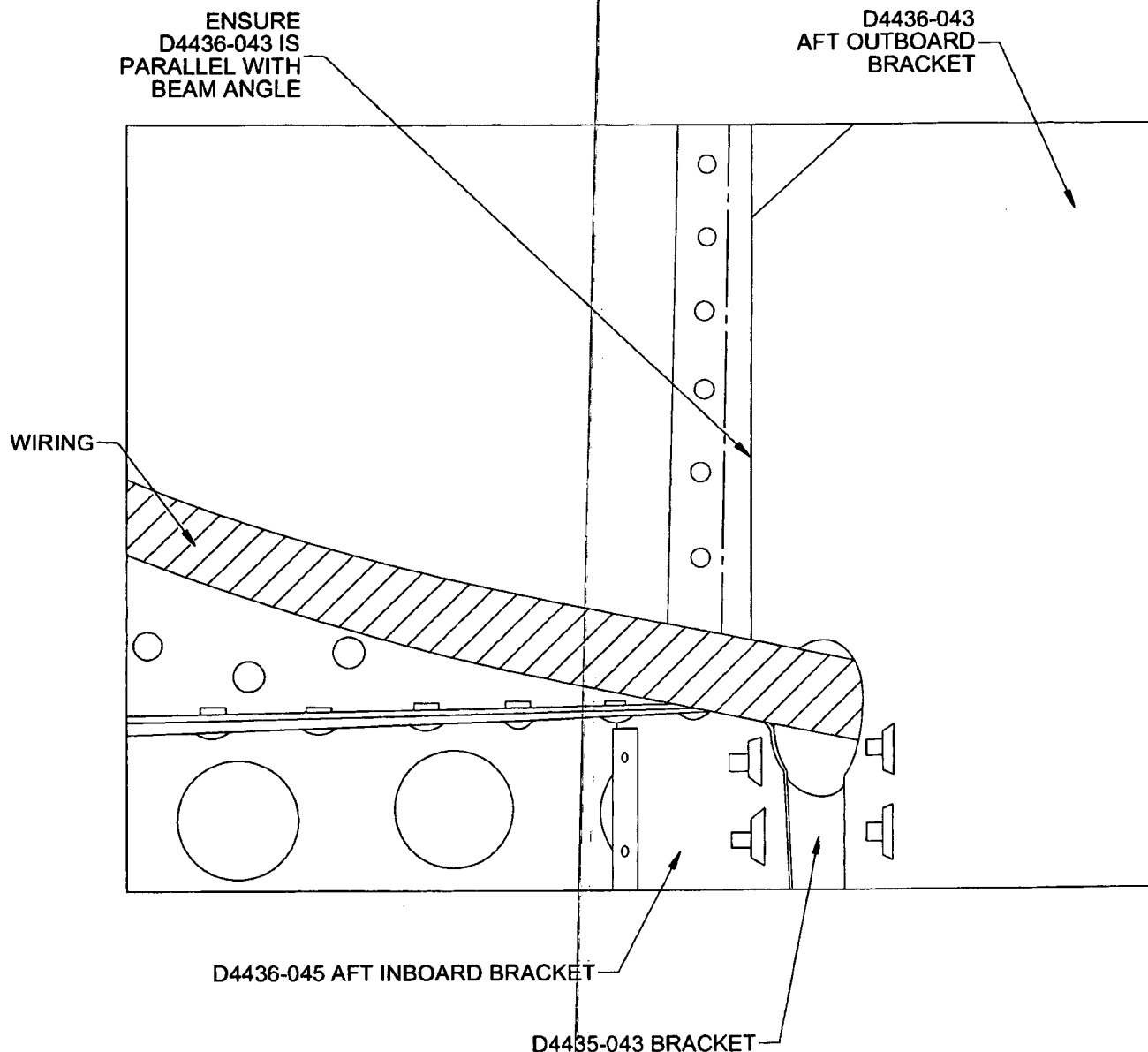


Figure 4. D4436-043 & D4435-043 Brackets Installation

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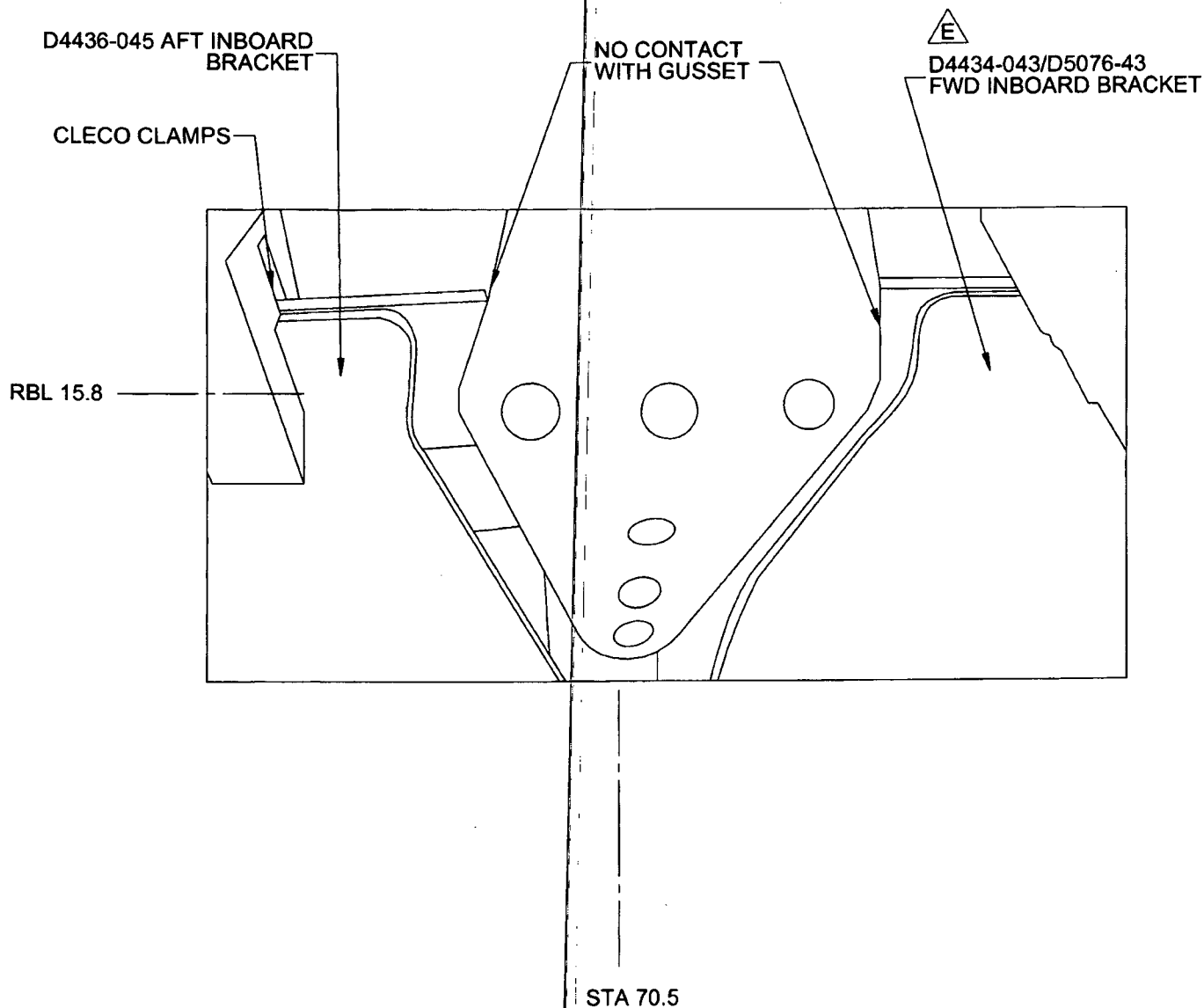


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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D4436-043
AFT OUTBOARD
BRACKET

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

WIRING

PLASTIC STAND OFF
REF

RIVET HOLE
FOR PLASTIC
STAND OFF

CLECO CLAMPS

D4436-045
AFT INBOARD
BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation

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DAO # 01-O-01

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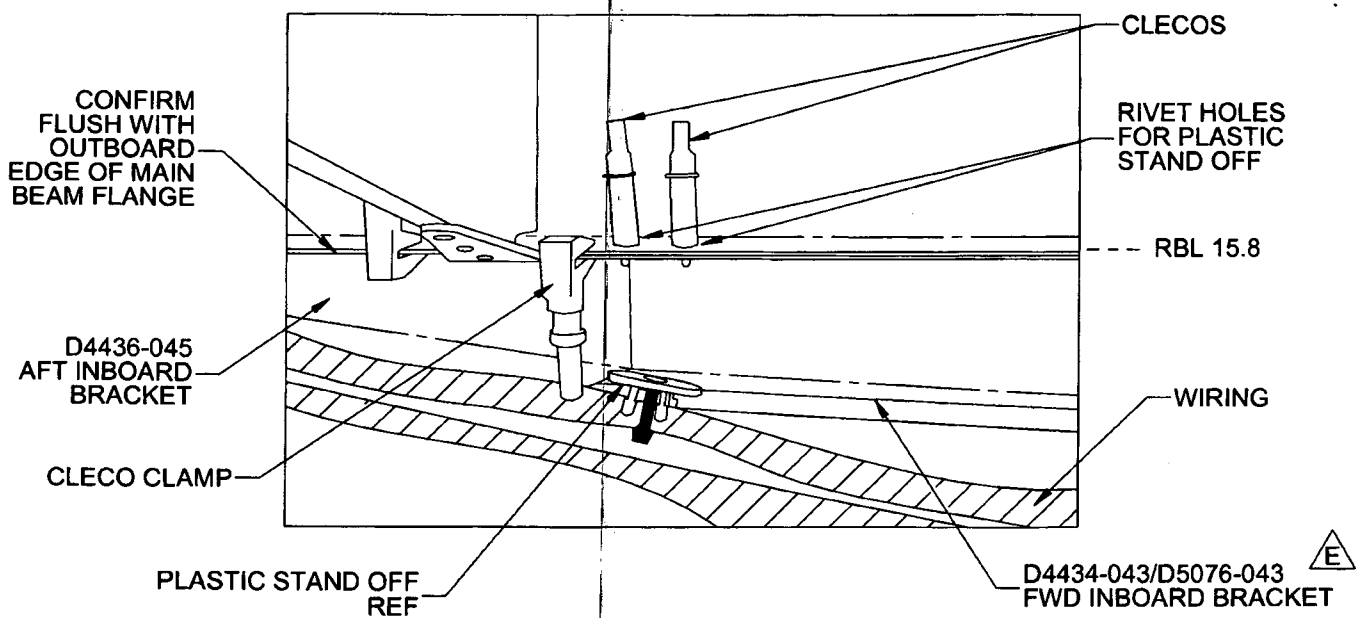


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

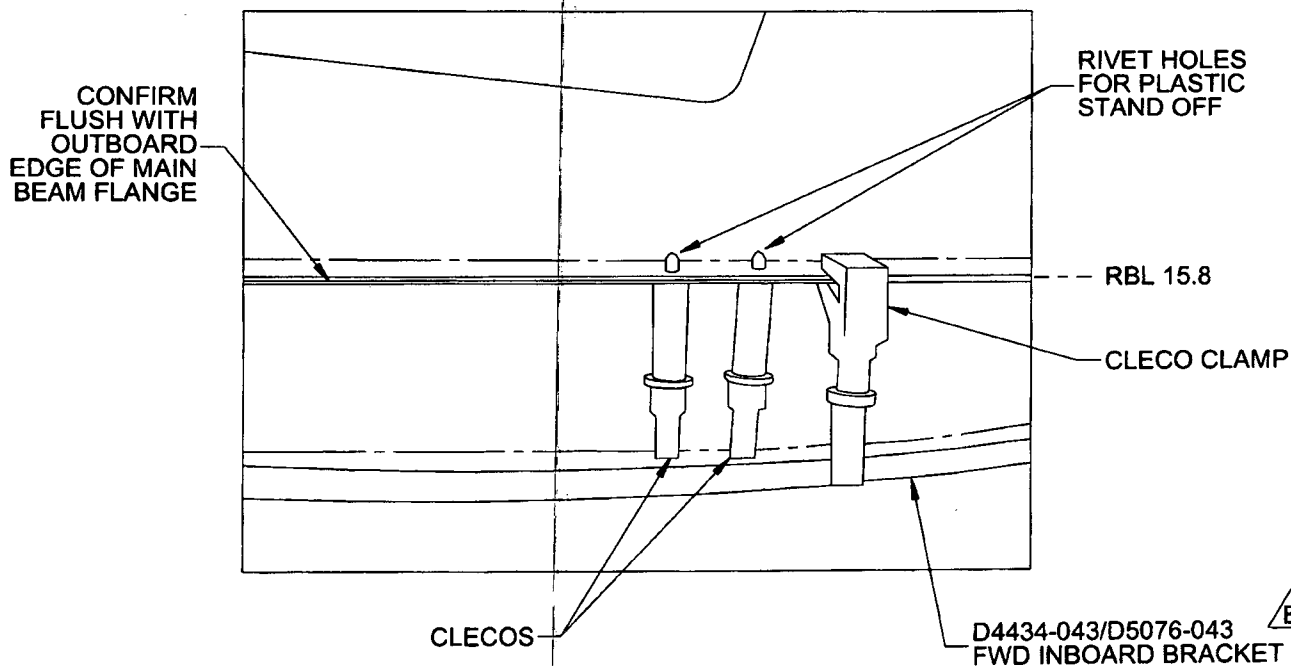


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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MFG. APPR.	N/A	SHEET 10 OF 19	
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INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

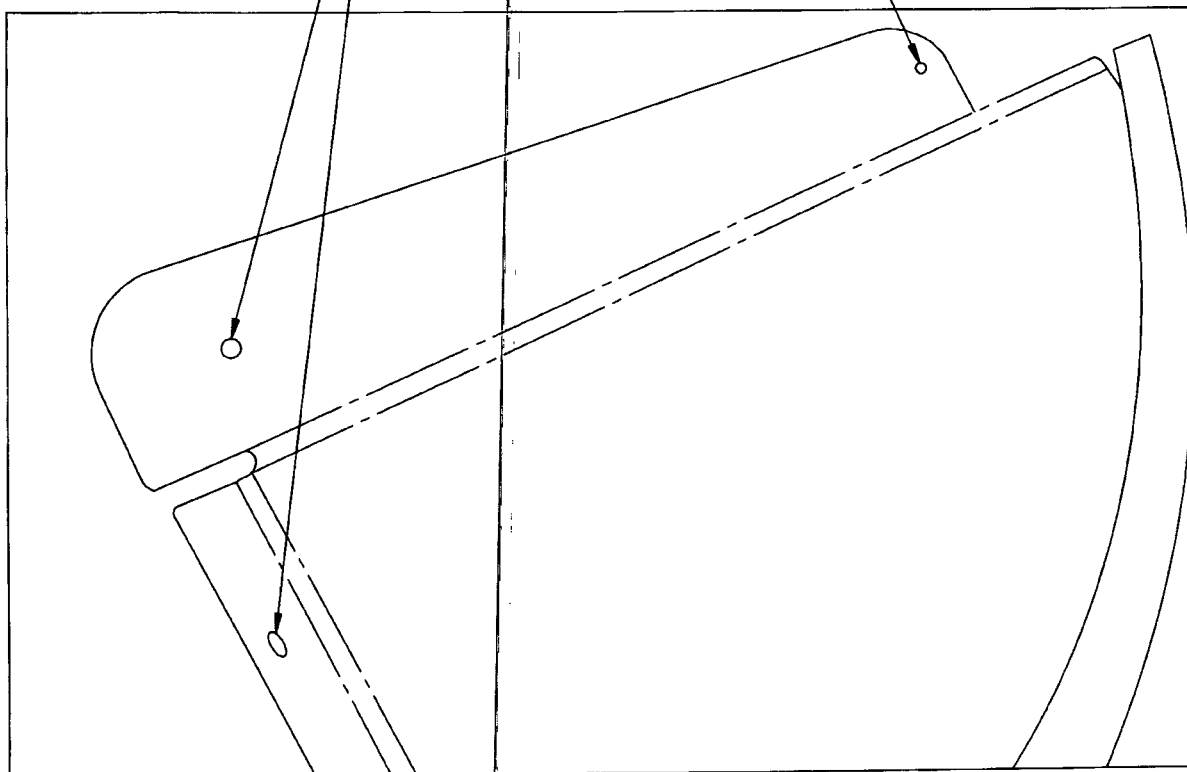


Figure 9. D4436-043 Aft Outboard Bracket Installation

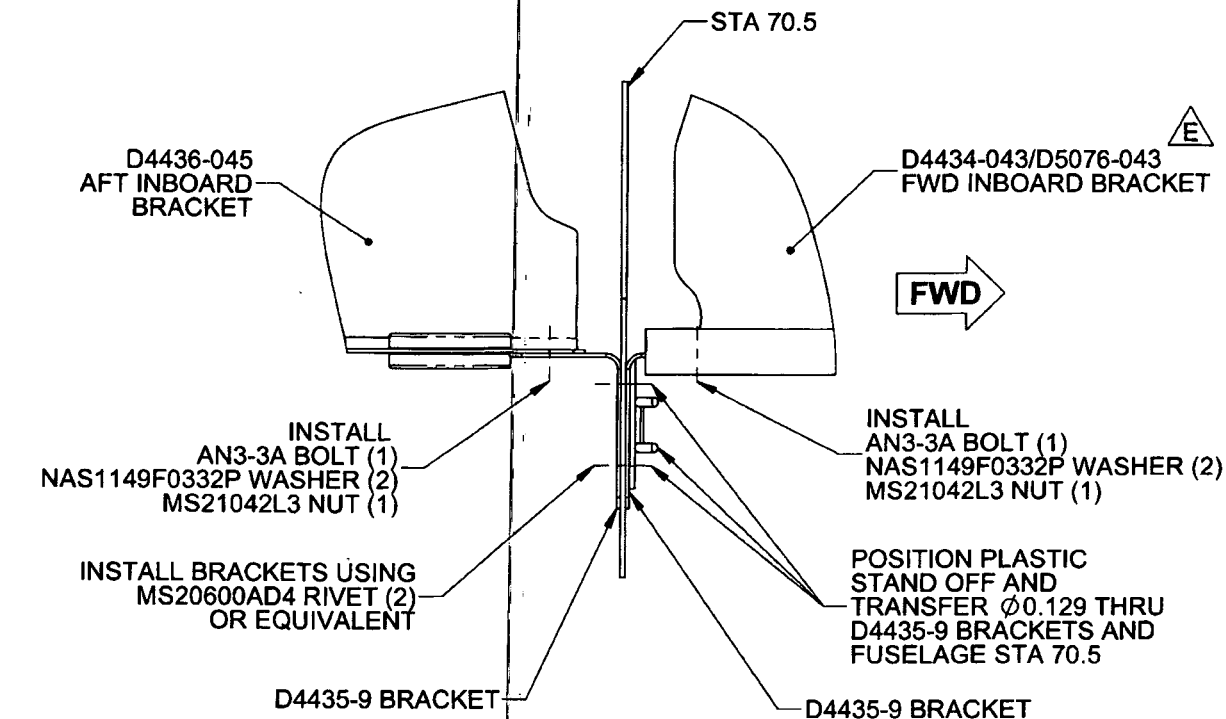
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LOOKING UP AT STA 70.5

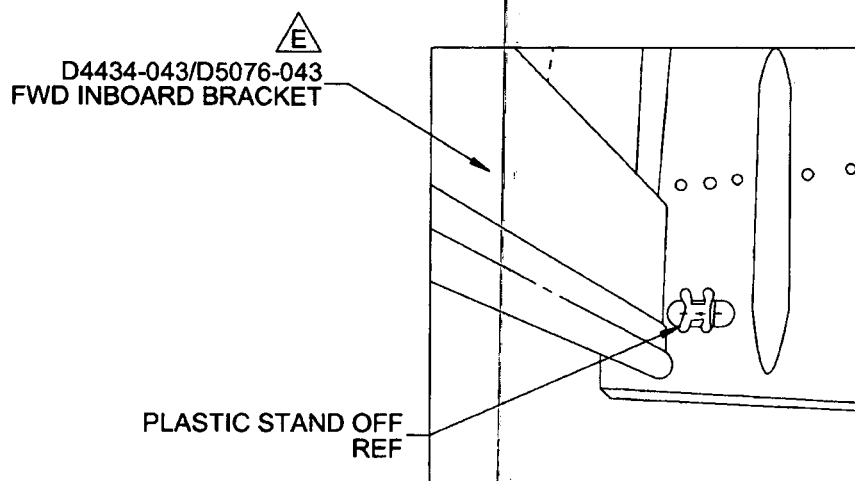


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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BRANCH
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D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	SHEET 12 OF 19	
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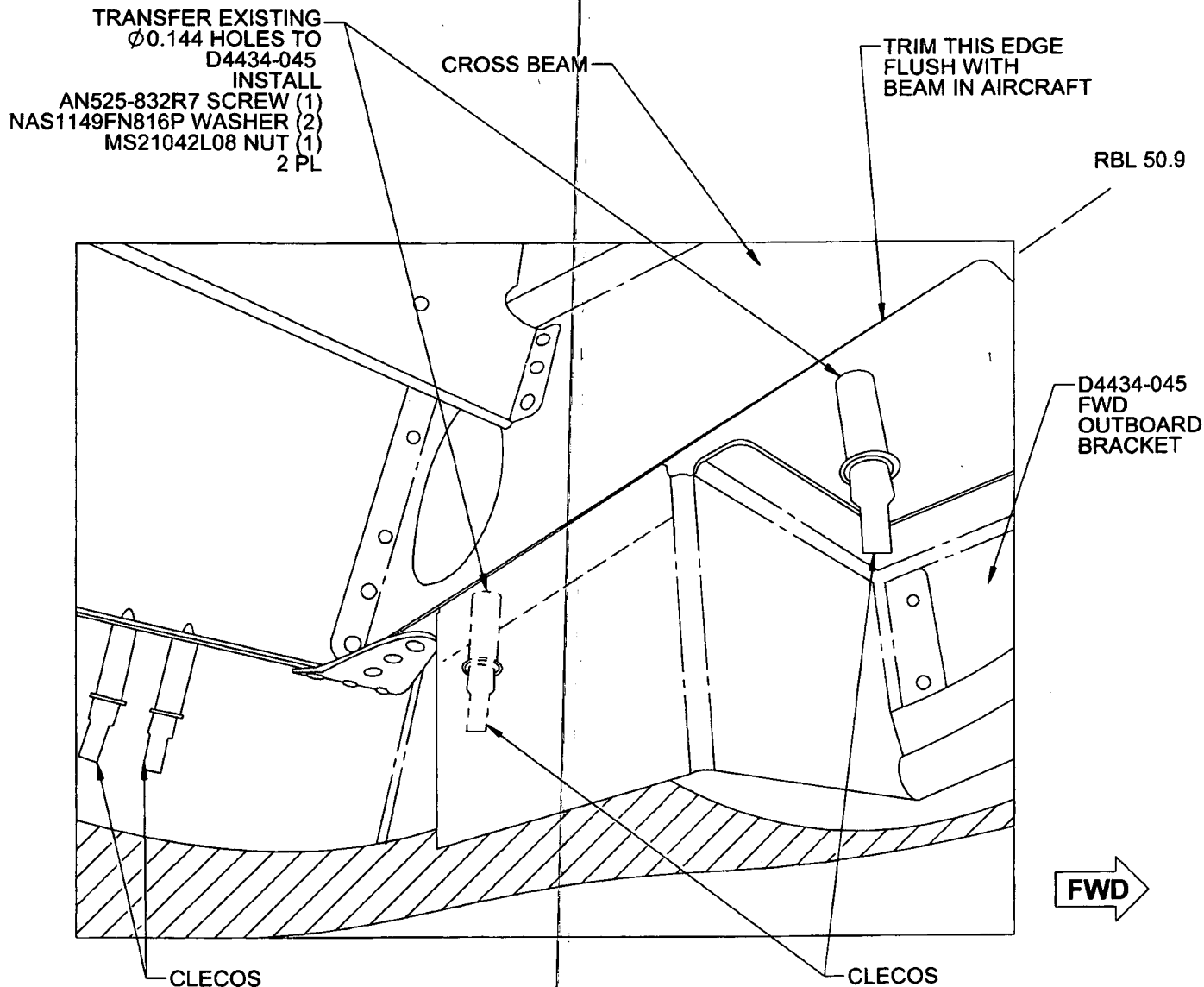


Figure 11. D4434-045 Bracket Installation

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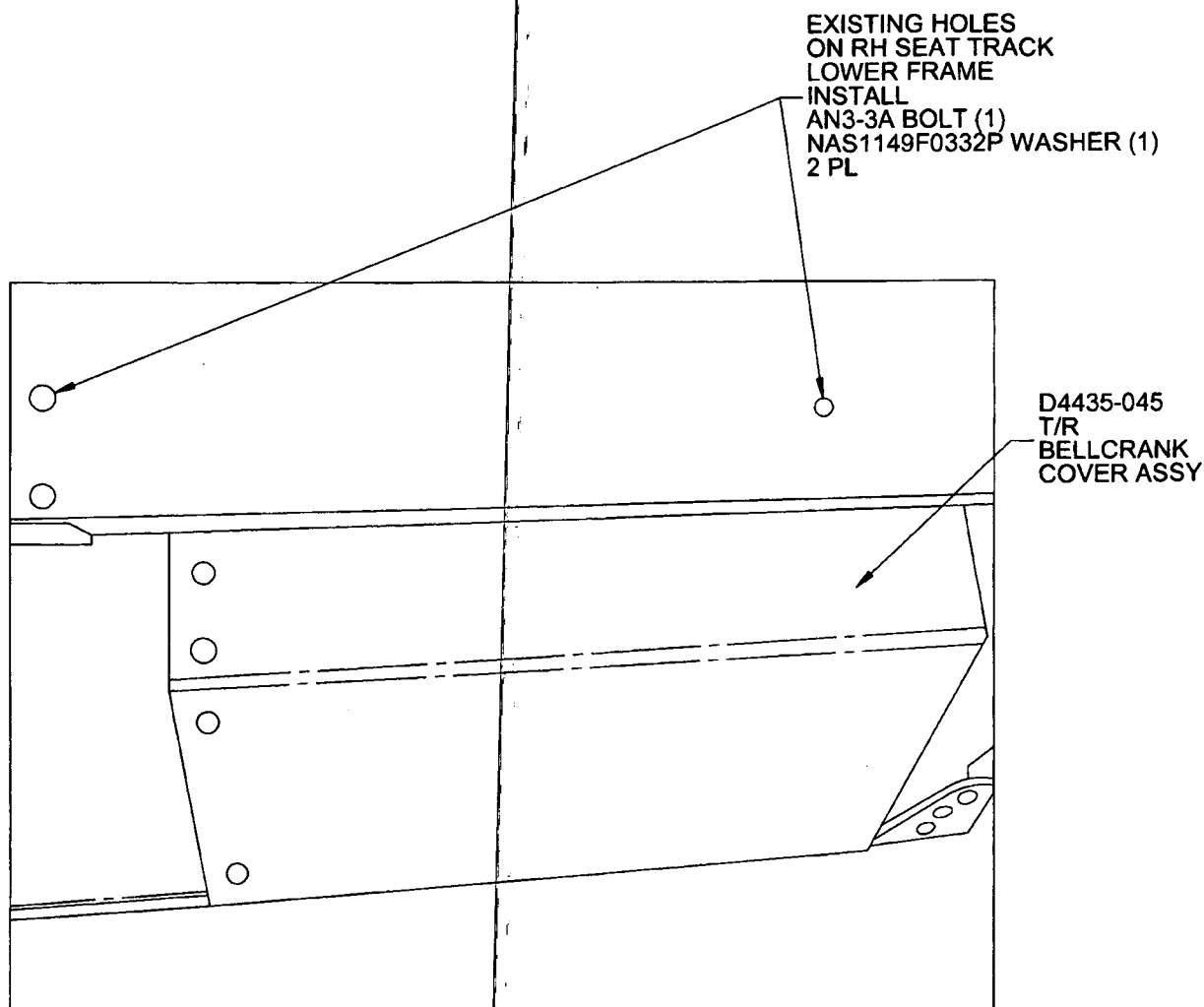


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

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DAO # 01-O-01

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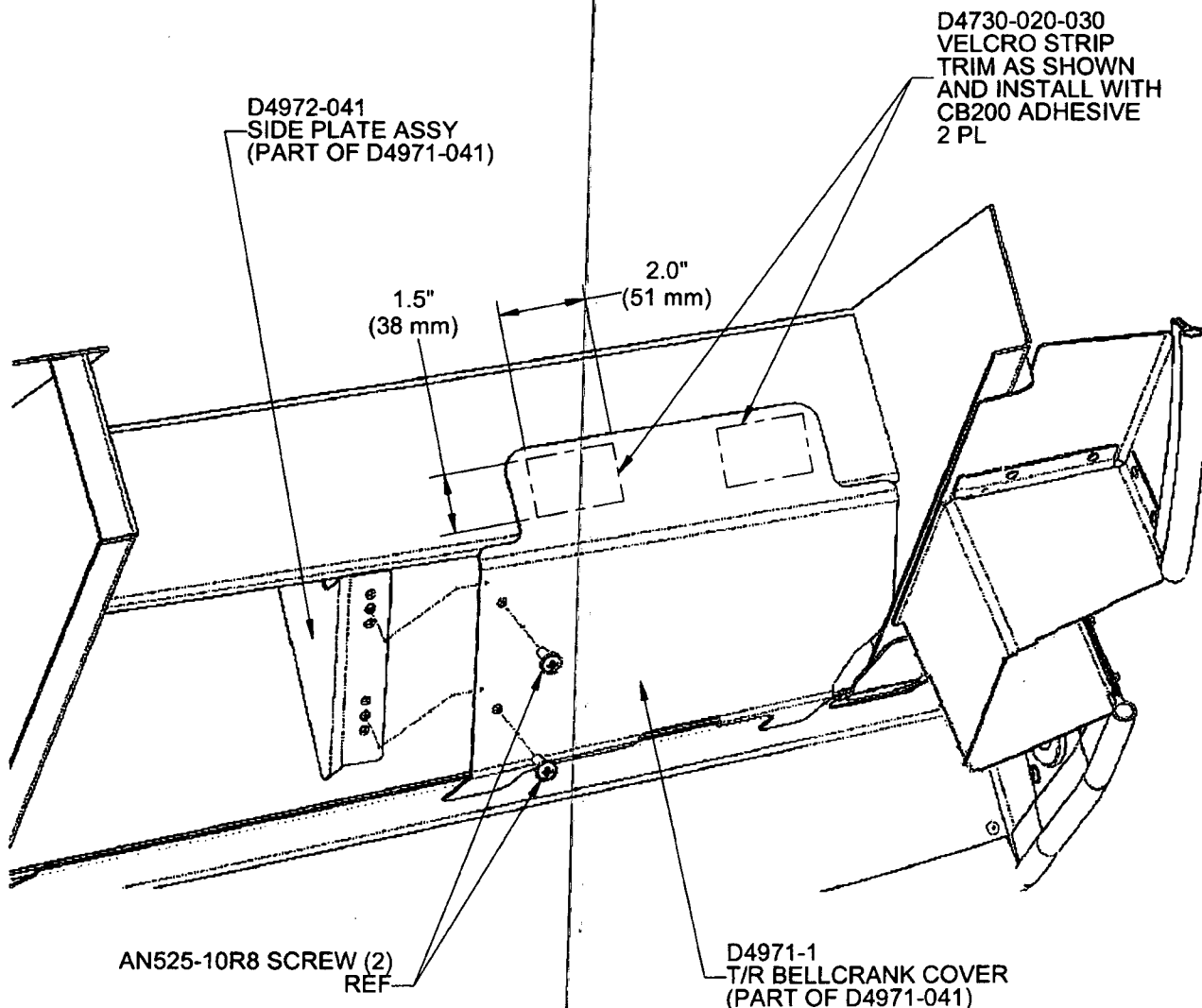


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

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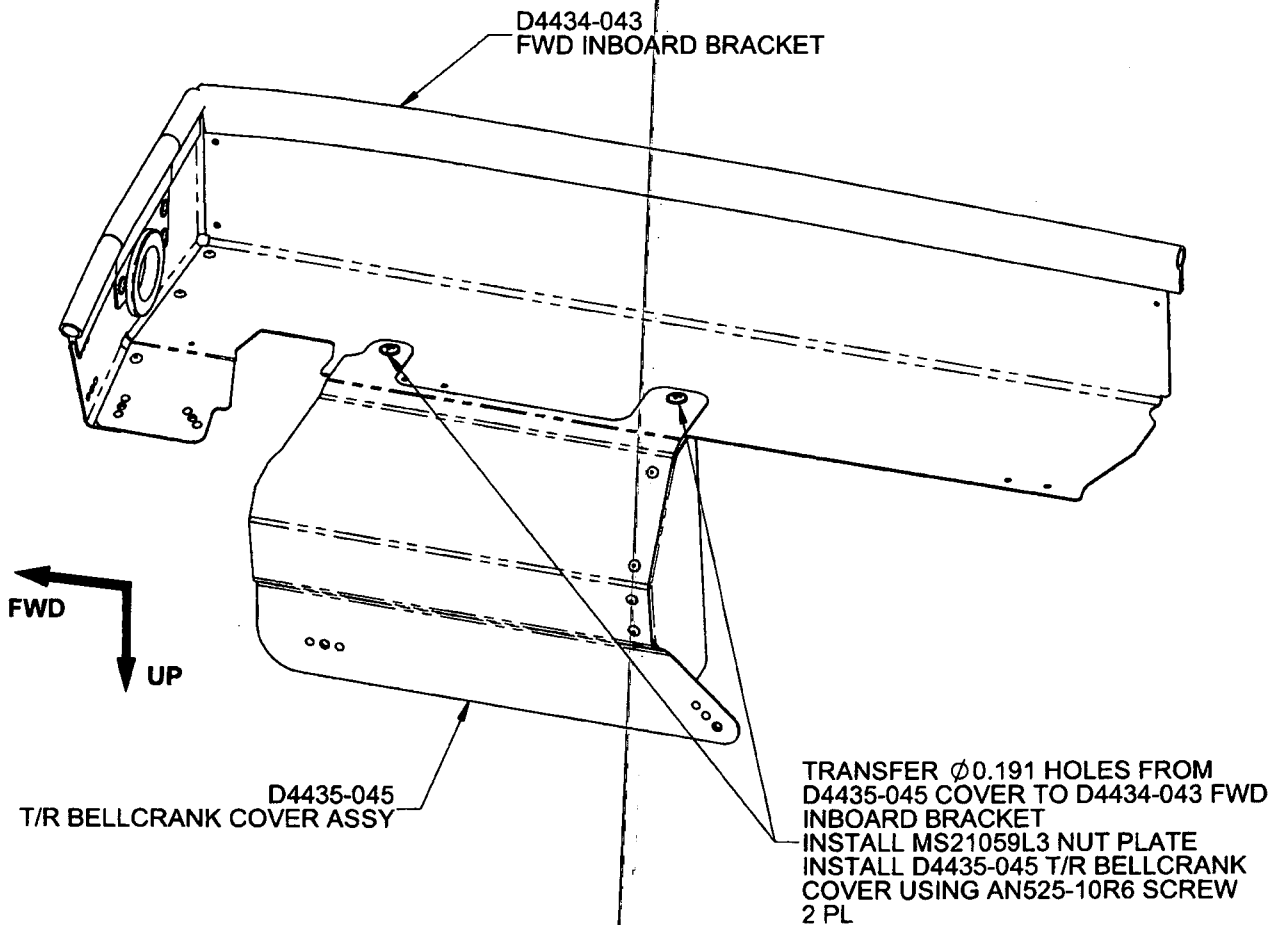


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

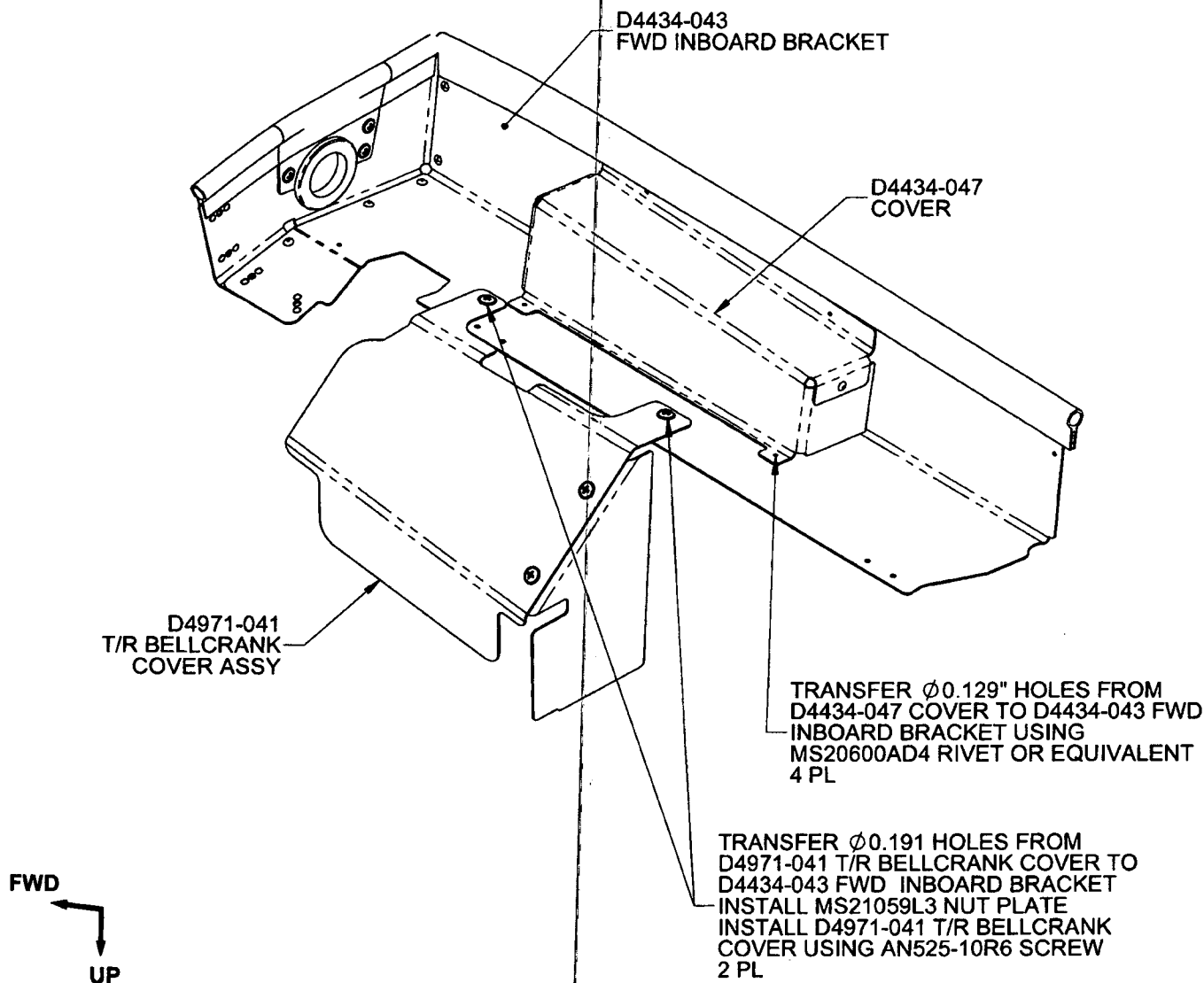
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E Figure 13b. D4971-041 & D4434-047 Cover Installation (-143 ONLY)

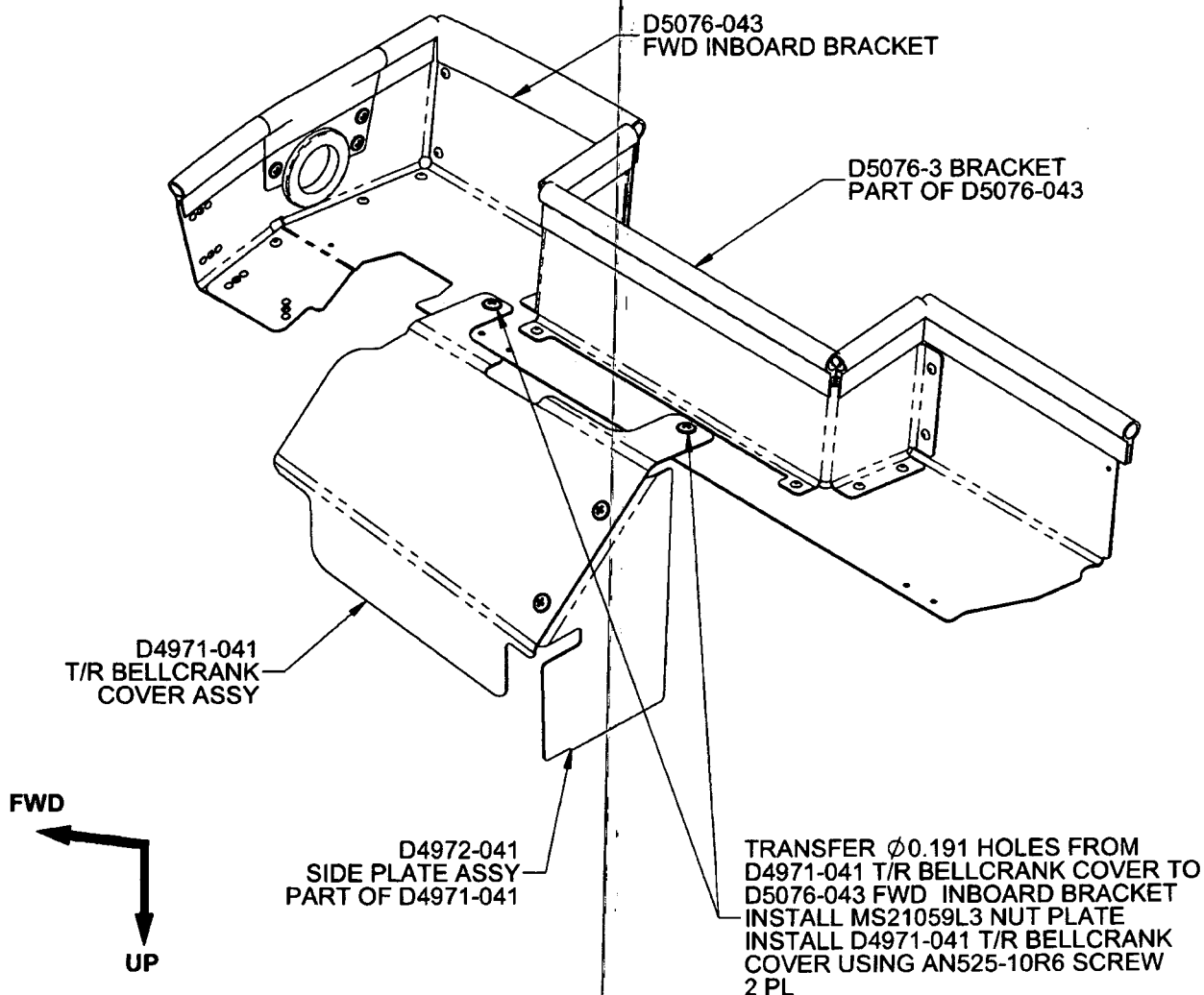
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E **Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)**

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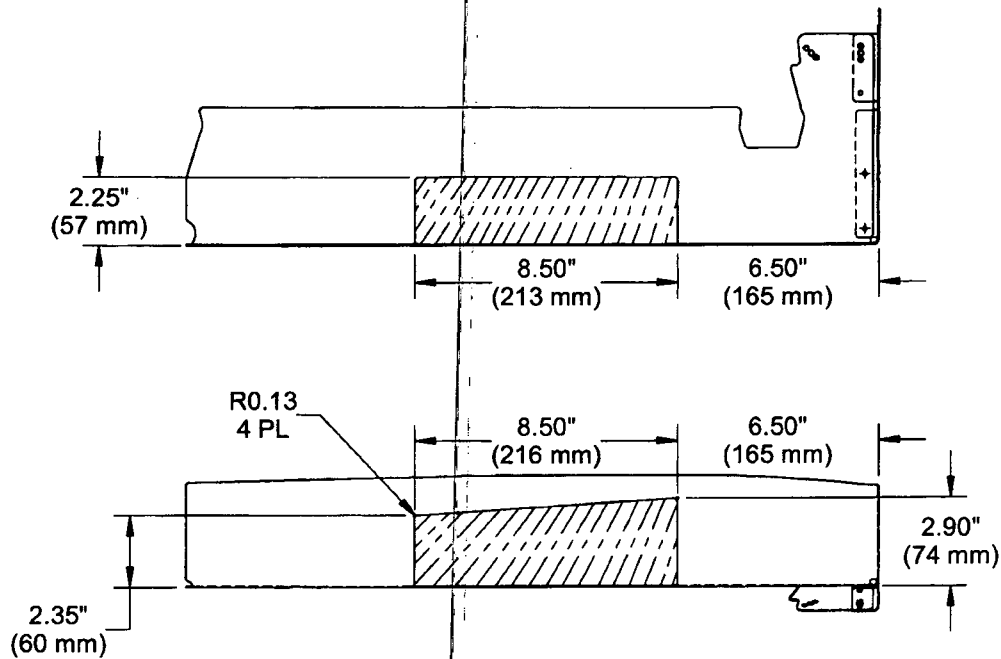
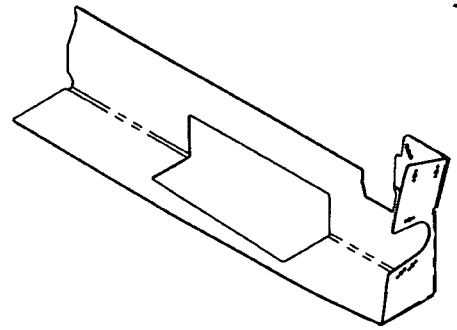


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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DAO # 01-O-01

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REFERENCE ONLY

DAS
06
00

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

E

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kG	65.5 in 1.66 m	255.5 in-lb 2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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